: CROSSBOLT SPACER

: D2579

: N/A

; E

. D2579 REV E

: 4/10/2008



Date.\* User:

Wednesday, 3/12/2008 1:41:57 PM

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

Material

Due Date

**Drawing Number** 

Project Number

**Drawing Revision** 

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: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 37856 -2

Estimate Number

: 10993

P.O. Number

: 3/12/2008

This Issue Prsht Rev.

: NC

First Issue Previous Run

: 11

: MACHINED PARTS Type

: 37752

Written By Checked & Approved By

Comment

Now turned on Cobra NG : Est E 02.06.17

est 07.07.06 rev E dwg

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

10

M6061T6T0500W058

6061-T6 Tube 500 x 058W

Comment: Qty.:

0.3762 f(s)/Unit Total: 112.8645 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6 ) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall

2.0 HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Comment: SECOND CHECK

50

PACKAGING 1

PACKAGING RESOURCE #1

SECOND CHECK



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

300 Um: Each





Page 1

Form mrocess

## **Dart Aerospace Ltd**

	- Donot													
W/O:			WORK ORDER CH											
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			ú	7.										
Part No	: 11	PAR #:	Fault Car	tegory:	_ NCI				_ Date: _					
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR	)							
DATE	OTED	Description of NC			tion B		Verific	ation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector				
	2								-					

NOTE: Date & initial all entries

Date: User: Wednesday, 3/12/2008 1:41:57 PM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 37856

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.04.03

## Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					d 22					
Part No	:	PAR #:	_ Fault Cate	egory:	NCF	R: Yes I	No DQA	١:	_ Date: _	
						QA: N/	C Closed	l:	_ Date: _	
NCR:		W .	ORK ORE	DER NON-CONFORMA	NCE	(NCR	)			
DATE	STEP	Description of NC	Description of NC Corrective Action		on B	Verifi		ation Approval	Approval	
DATE	DATE STEP Section A		Initial Chief Eng				Sign & Section		Chief Eng	QC Inspector
	TANKST NUMBER OF STREET									
	West Services									
	Mark to Mark									

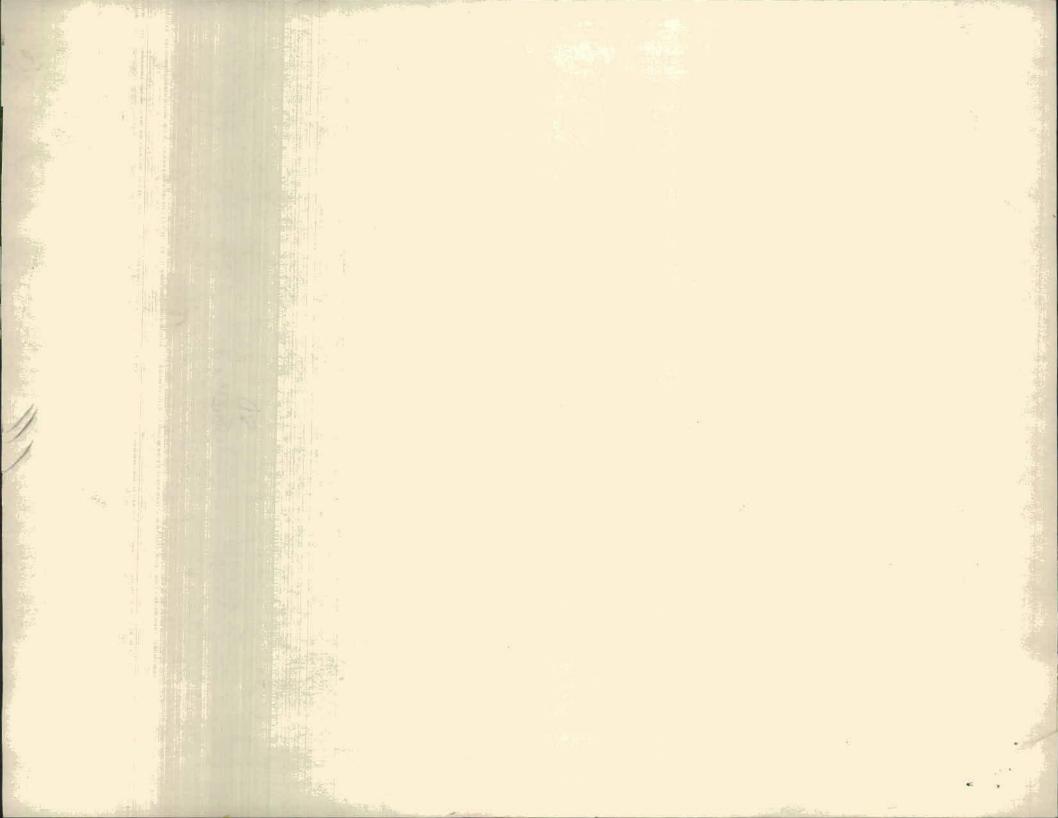
NOTE: Date & irritial all entries

DART AEROSPACE LTD	Work Order:	37856
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

		X First Article P			Prototype			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
4.070	+/-0.030	4.075	V ,					
0.058	+/-0.010	.058						
<u> </u>								
Measured by:	S.F.	Audited by:	2.0	P	Prototype Approva	al: N/A		
	04/04/81	Date:	08,04	01	Dat	e: N/A		

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM X	R





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED.	DRAWING NO. REV. E D2579 SHEET 1 OF 1
DATE		TITLE SCALE
07.04.1	7	CROSS BOLT SPACER 1:1
Α	96.09.16	NEW ISSUE
В	96.12.05	0.065 WALL WAS 0.035 WALL
С	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)

UPDATE NOTES



-	4	.070±0.	030 —	

07.04.17

# Ø0.500 -Ø0.38 (REF -0.058

### D2579 CROSS BOLT SPACER

E

#### D2579 CROSS BOLT SPACER

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6T0500W058) MATERIAL: SUBJECT TO AMENDMENT

(REF DART SPEC M6061T6T0500W058)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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